

Date: Tuesday, 5/9/2006 9:52:03 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
Job Number : 27045	
Estimate Number : 10460	
P.O. Number : N/A	Part Number : D350591113
This Issue : 5/9/2006 S.O. No. : N/A	Drawing Number : D2310 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : D
Previous Run : 24518	Material : N7A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/19/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: <u>4</u> Um: Each
Comment : Est Rev:H 04.11.09 Reformat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2244	Step Extrusion	<u>B23404</u>

RE 06-05-09 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

RE 06-05-09 4
RE 06-05-09 4
RE 06-05-09 4

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

RE 06-05-09 (4)

4.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D2673-34	End Cap	<u>B25396</u>

RE 06-05-09 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/9/2006 9:52:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27045

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing B17557

LE 06.05.09

4

6.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2582

Step Leg Assembly B25395

LE 06.05.09

4

7.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part number

Description

Batch

16 MS20600AD4W3 Rivet

M13767

LE 06.05.09

4

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD Batch: M19173 M15689

2-Grind end cap and bottom bushing welds flush

FF 06.05.10 4 / LE 06.05.10 bottom

3-Machine top weld on bushing flush

LE 06.05.10

4

4

4

9.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

*06.05.12 (4)
PD 06.05.15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27045

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LE 06-05-18

(10) 4

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

~~64~~ 64 rivets used

LE 06-05-23

4

2-Inspect for foreign object as per QSI 024

LE 06-05-23

4

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: 119173

LE 06-05-23

4

4-Grind end cap welds flush

LE 06-05-23

4

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-05-23

4

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

DL 06/05/23

(4)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/23

(4)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: 1100652

FL 06 05 23

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
0605-18	10.1	Add QC3 for Alodine. Permanent change. <i>[Signature]</i> Inspected by <i>[Signature]</i> 0605-18 (41)					<i>[Signature]</i> 0605-18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/05/18

NOTE: Date & initial all entries

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Job Number: 27045

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALL

06-05-24 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

K591113

Short Step Instln Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

27046

06/05/24 (4)

19.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/24 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location:

RW 11

06/05/24 (4)

21.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D

06/05/24 (4)

Job Completion



C Loe 10/5/23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

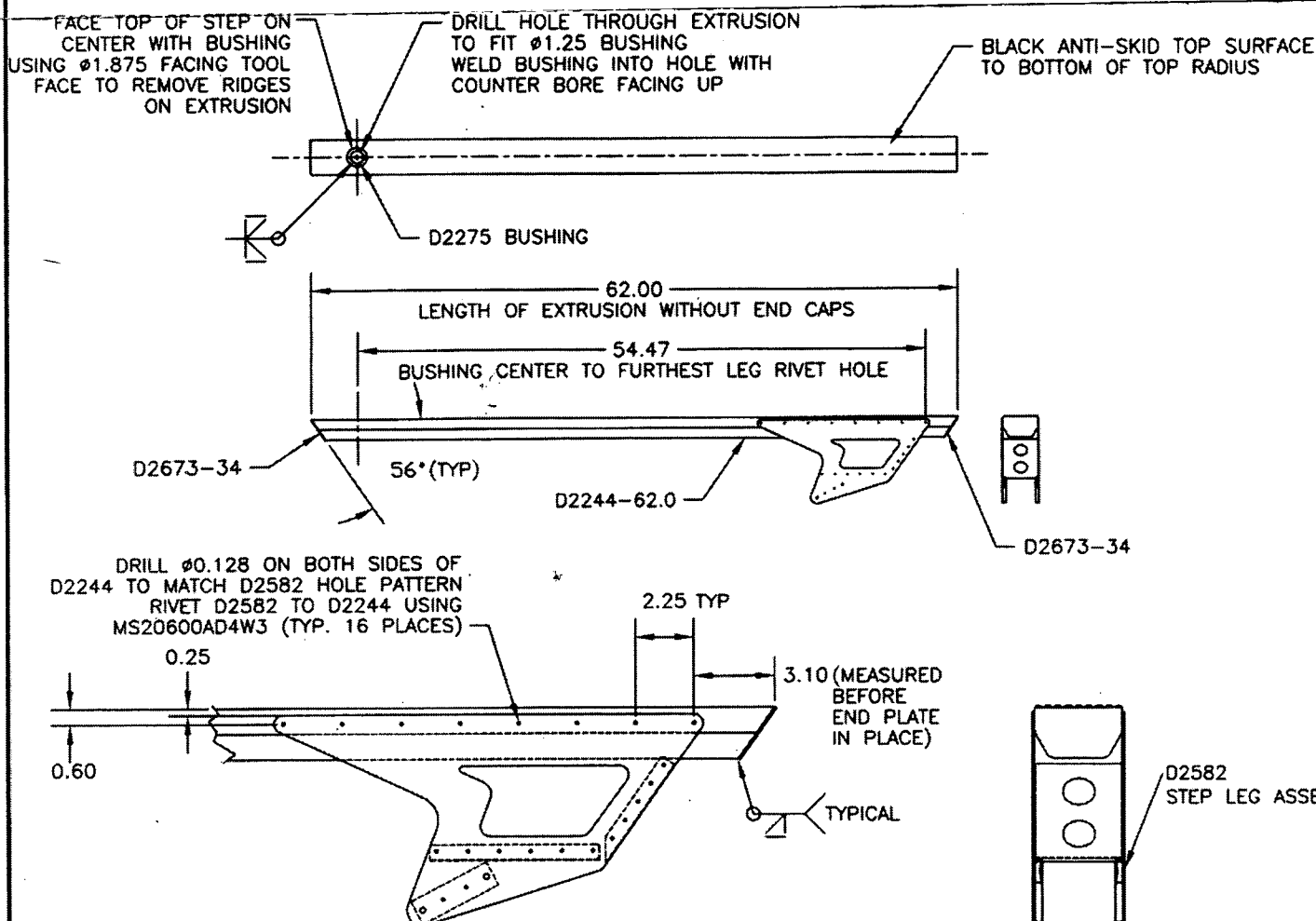
QA: N/C Closed: _____ Date: _____

DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2310	REV. 0
				SHEET 2 OF 2
				SCALE
				NTS

HIGH SHORT STEP ASSEMBLY

REFERENCE ONLY



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

REFERENCE ONLY

RELEASED
05.11.28

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